

Date: Tuesday, 4/24/2007 3:14:53 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	STEP LEG		
Job Number	32032C					
Estimate Number	10382					
P.O. Number	N/A		Part Number	D30655		
This Issue	4/24/2007 S.O. No. N/A		Drawing Number	D3065 REV. B		
Prsh Rev.	NC		Project Number	N/A		
First Issue	N/A		Drawing Revision	B		
Previous Run	31794C		Material	N/A		
Written By			Due Date	5/20/2007 Qty: 120 Um: Each		
Checked & Approved By	<u>JL</u> 07-04-25					
Comment	Est:C 02/11/01 Incorporated D3066-1 IPP KJ/RF Est Rev:D Now on Water Jet 06-04-11 JLM Est Rev:E Now manufactured with 6061-T6 06-05-25 JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6S080	6061-T6 .080 Sheet	
		Comment: Qty.: 1.1338 sf(s)/Unit Total : 136.0548 sf(s) Material: 6061-T6 0.080" thick (M6061T6S.080)	Batch: <u>4/04 392 96</u> <u>4/04 326 (31) SAD 07/05/22 126</u>
2.0	WATER JET	FLOW WATER JET	
		Comment: FLOW WATER JET 1-Cut as per Dwg D Dwg Rev: <u>B</u> Prog Rev: <u>B</u>	Prog Rev: <u>B</u>
		2-Deburr if necessary	SAD 07/05/22 126
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	SAD 07/05/22 126
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	<u>4/05-29 126</u> <u>counted</u>
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr Stack	<u>mf</u> 07-06-07 <u>126</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3065-5 PAR #: NA Fault Category: Prod/Fab. Ass' med & small NCR: Yes No DQA: ✓ Date: 07/06/11
 QA: N/C Closed: ✓ Date: 07.06.11

NCR: 32032C		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/05/23	2.0	One piece was scrap because machine offset had to be change	<u>Q</u> QS1042	Scrap - destroy replace	SFD 07/05/23	<u>Q</u> QS1042	<u>Q</u> QS1042	<u>Q</u> QS1042
07/05/23	2.0	missing not enough material to finish the step legs	<u>Q</u> QS1042	Scrap destroy replace	SAP 07/05/23	<u>Q</u> QS1042	<u>Q</u> QS1042	<u>Q</u> QS1042

NOTE: Date & initial all entries

Date: Tuesday, 4/24/2007 3:14:53 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP LEG

Job Number: 32032C

Part Number: D30655

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SD 07/06/07

(126)

7.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

MF

07-06-08

(126)

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

MF 07-06-08

(126)

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: G-A

MF

07-06-08

(126)

10.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

SD 07/06/11

(126)

Job Completion



Not done

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	32032C
Description: Step Leg	Part Number:	D3065-5
Inspection Dwg: D3065	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

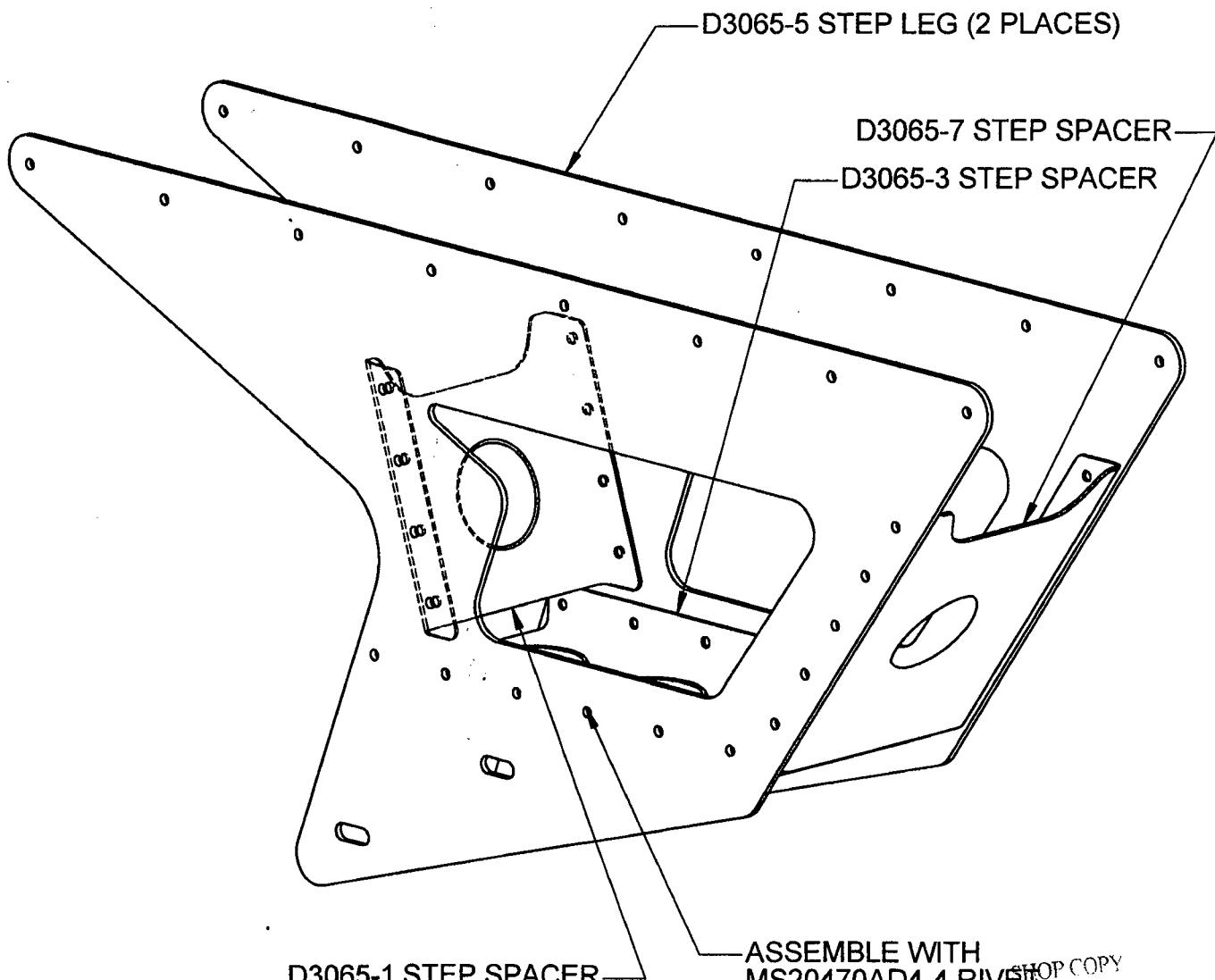
Measured by:	JAD	Audited by:	BG	Prototype Approval:	N/A
Date:	07/05/22	Date:	07-05-22	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D3065-041	KJ/RF	
B	04.06.15	Added Ø0.128 dimension	KJ/JLM	
C	06.06.23	Dwg Rev. changed	KJ/JLM	<i>[Signature]</i>

DART

DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065
DATE 06.05.23	TITLE STEP LEG ASSEMBLY	REV. B SHEET 1 OF 5 SCALE 1:2

RELEASED

06.06.20 *[Signature]***D3065-041 STEP LEG ASSEMBLY**

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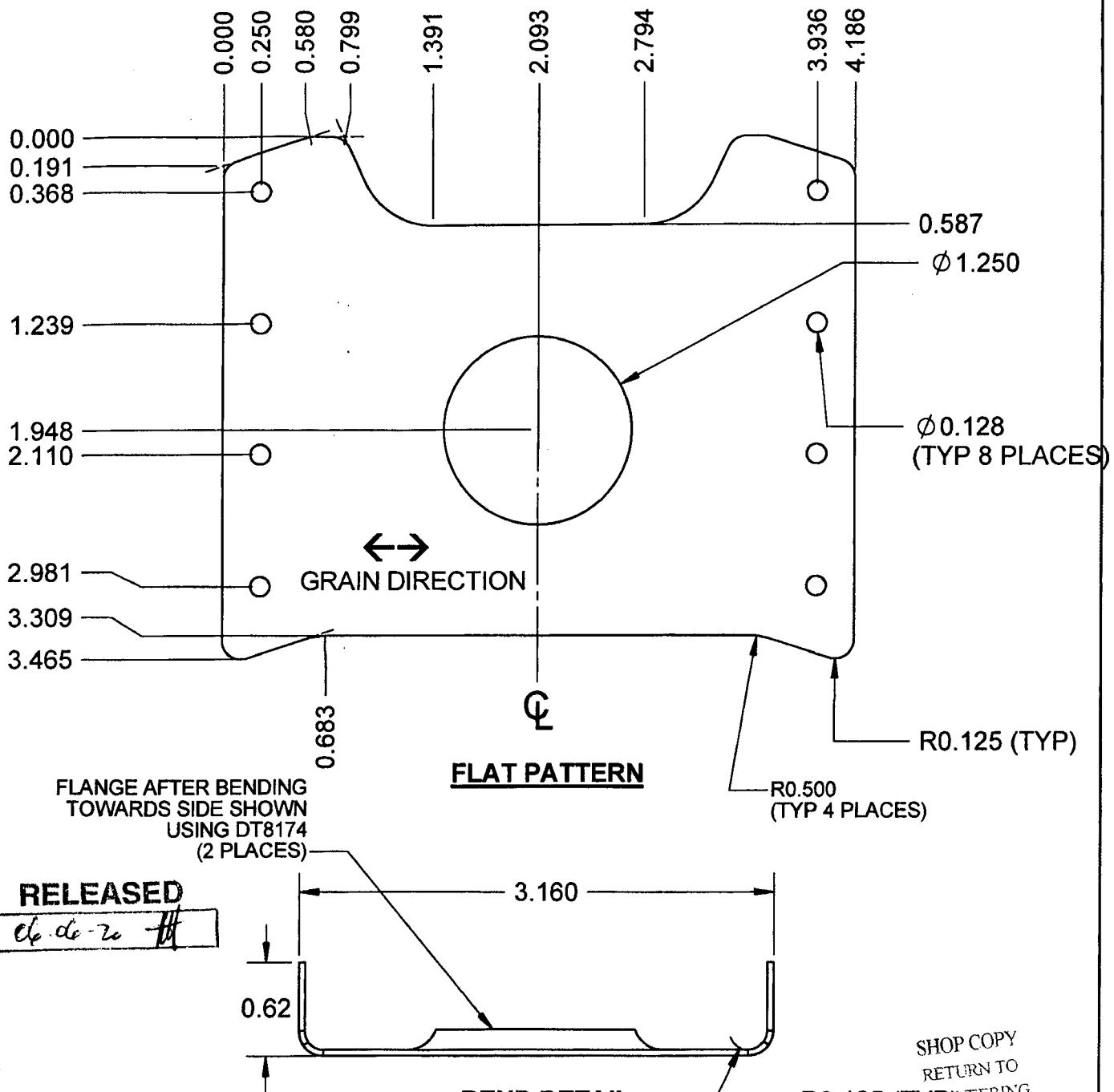
WORK ORDER
NO *32032C*

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CHECKED <i>PH</i>	APPROVED <i>MM</i>	DRAWING NO. D3065	REV. B SHEET 2 OF 5
DATE 06.05.23	TITLE STEP LEG ASSEMBLY	SCALE 1:1	

**D3065-1 STEP SPACER**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

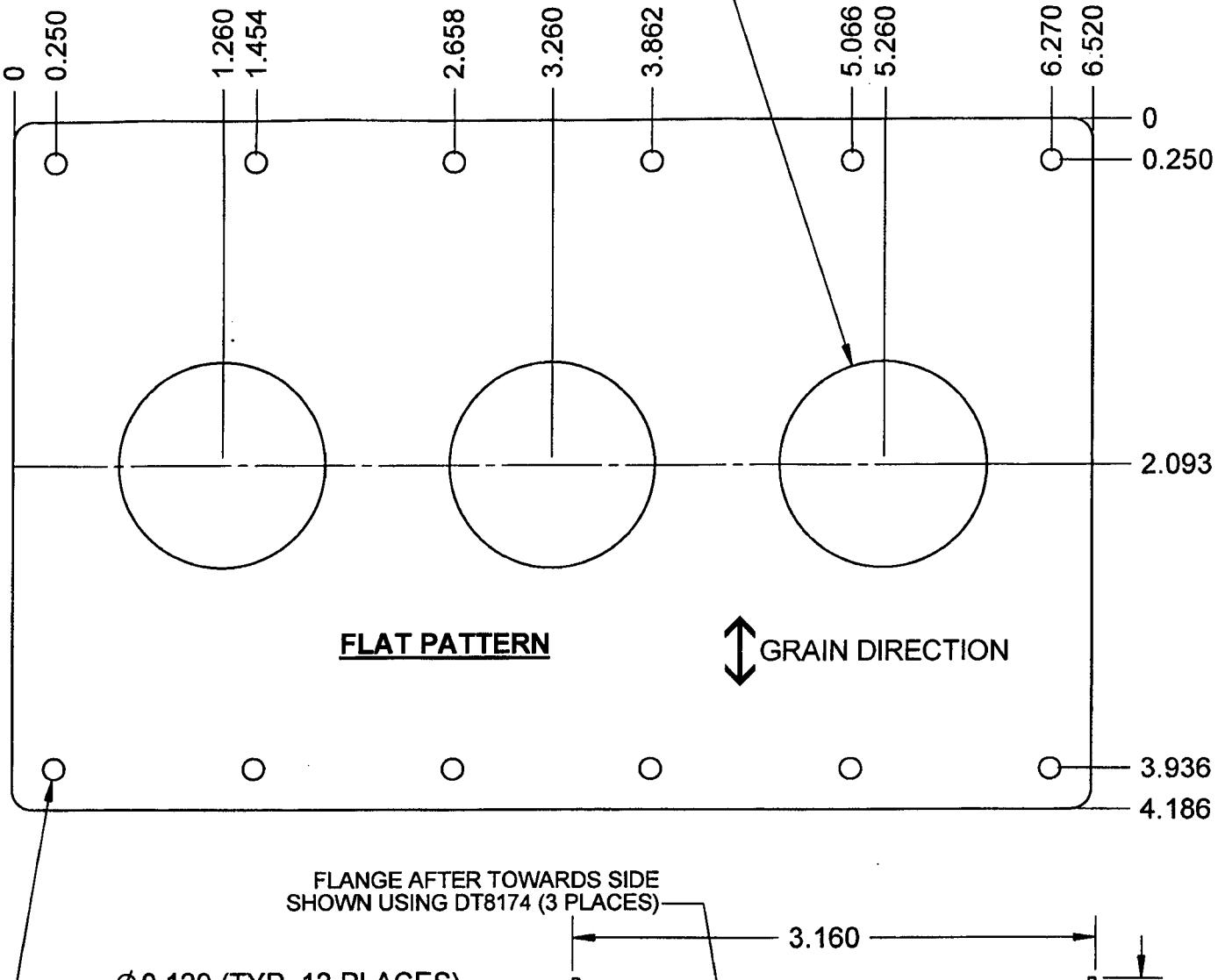
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CHECKED <i>PH</i>	APPROVED <i>MM</i>	DRAWING NO. D3065	REV. B SHEET 3 OF 5
DATE 06.05.23	TITLE STEP LEG ASSEMBLY	SCALE 1:1	

 $\emptyset 1.250$ (TYP, 3 PLACES)**D3065-3 STEP SPACER**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4)
0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

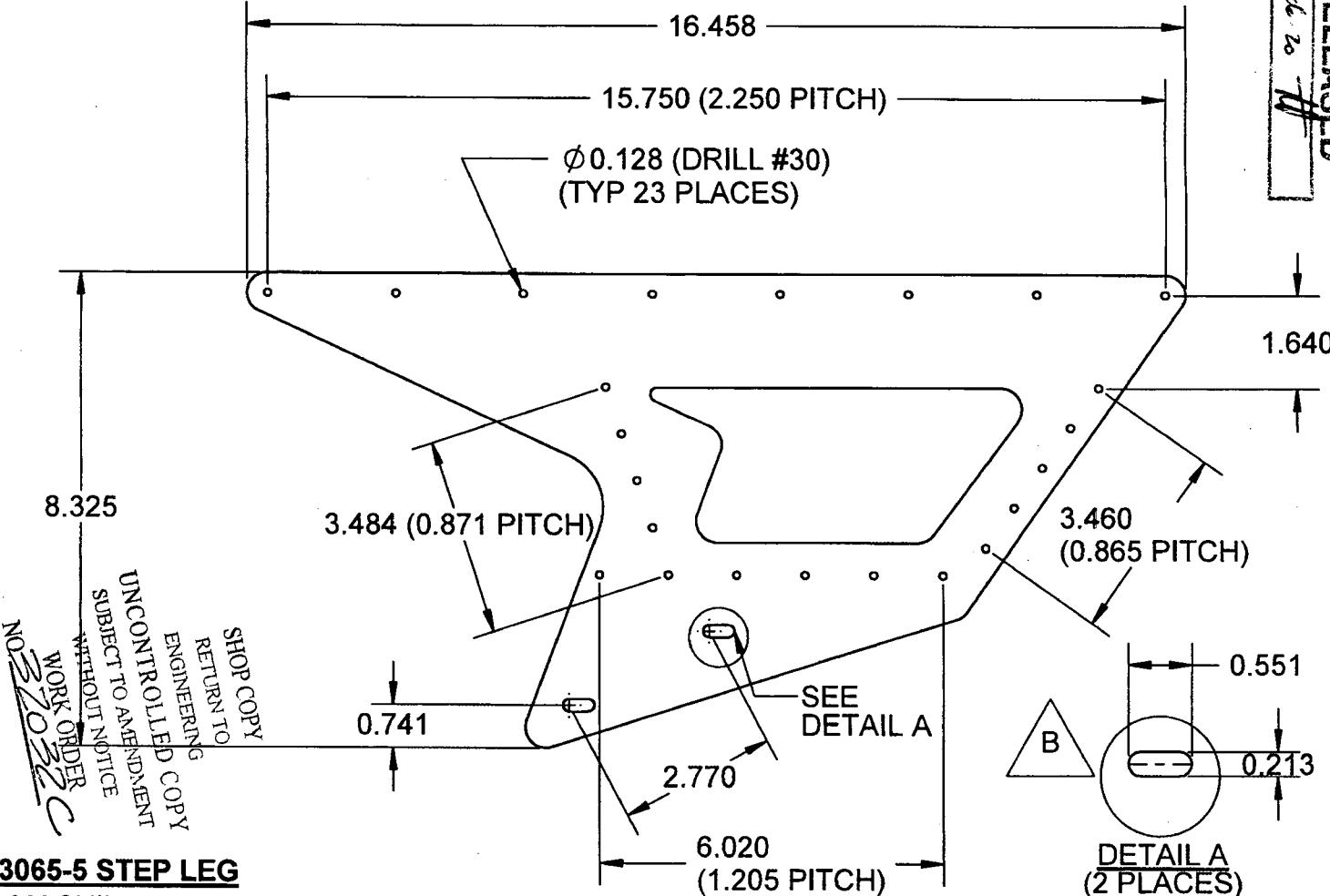
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CHECKED <i>P.H.</i>	APPROVED <i>M.</i>	DRAWING NO. D3065
DATE 06.05.23	TITLE STEP LEG ASSEMBLY	REV. B SHEET 4 OF 5 SCALE 13

**D3065-5 STEP LEG**

- 1) MACHINE PER DWG FILE "D3065-5.SLDPRT"
- 2) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK
(REF DART SPEC M6061T6S.080)
OR
5052-H32 (PER QQ-A-250/8 OR AMS 4016) 0.080 THICK (REF DART SPEC. M5052H32S.080)
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

DART

DESIGN <i>IP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>✓</i>	DRAWING NO. D3065	REV. B SHEET 5 OF 5
DATE 06.05.23		TITLE STEP LEG ASSEMBLY	SCALE 1:1

